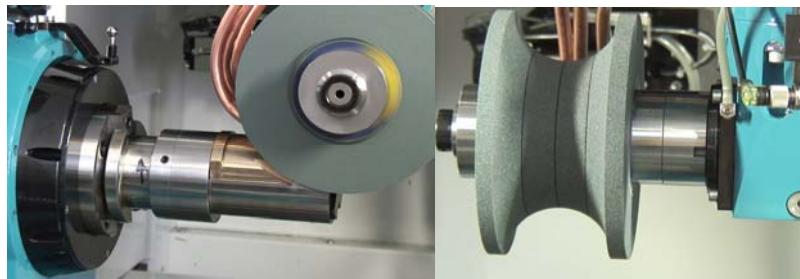


## Tool working Pipe

A30-200

The tool is produced by a solid cylinder with conventional wheels. It allows to change the spline geometry fast and economically by simply changing the wheel-DXF and redress the new geometry on the same wheel, and for small splines the wheel can be kept sharp as being redressed when needed.



### 1. Cycletime for Production

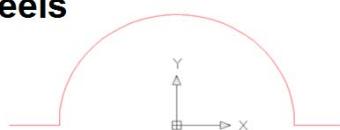
Tool specifications	
Diameter	139 mm, Z26, Length of cutting edge 90mm,
depth tooth:	5.3mm, Material 18NiCrMo7-6+HH

Operations	
	Dress
	Flute
Feed [mm/Min]	120
Power [kW]	1
Cutting feed [m/s]	32
Used wheels	1
Grinding time [s]	120
Total cycle time	26 Min 00

The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

### 2. Used Grinding Wheels

1 Ø125 DXF Conventional



### 3. Machine and Software Requirements



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Machines: 5 axes CNC grinders : NORMA CFG  
Control: Fanuc 31i  
Coolant: Synthetic Oil, pressure 6 - 7 bar  
Software: Quinto 5  
Engineer: Diego Albiero, 01.04.2009